

Date: Thursday, 23/04/2009 1:33:57 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2893-1
Job Number : 47395	
Estimate Number : 13234	
P.O. Number :	Part Number : DSK078
This Issue : 23/04/2009 S.O. No. :	Drawing Number : DSK078 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 46924	Material :
Written By :	Due Date : 30/04/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.04.23</u>	
Comment : est rev A. 08.03.13 new issue EC	
Est Rev:B 09-04-09 Now on Doosan Lathe JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104005	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Support

M47096

ink 09/04/26

(5)

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN LATHE
 Turn blank as per Folio FA081

ink 09/04/26

(5)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ink 09/04/26

(5)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/04/27

(5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock in Kanban
 Location: _____

ink 09/04/27

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 1:33:58 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 47395

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/27
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	47395
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.708	2.710	2.709	2.707
B	4.946	4.966		4.954	4.952	4.953	4.957	4.959
C	3.064	3.084		3.076	3.076	3.076	3.076	3.076
D	0.718	0.738		.727	.726	.726	.726	.726
E	0.090	0.110		.102	.101	.101	.100	.102
F	2.934	2.954		2.946	2.945	2.945	2.945	2.945
G	2.166	2.186		2.175	2.175	2.174	2.175	2.174
H	3.890	3.910		3.901	3.901	3.901	3.901	3.901
I	0.914	0.934		.927	.927	.927	.927	.927
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.117	.117	.116	.117	.117
L								
M								
N								
O								
P								

Measured by: ML Date: 09/04/26

Audited by: SA Date: 09/04/27

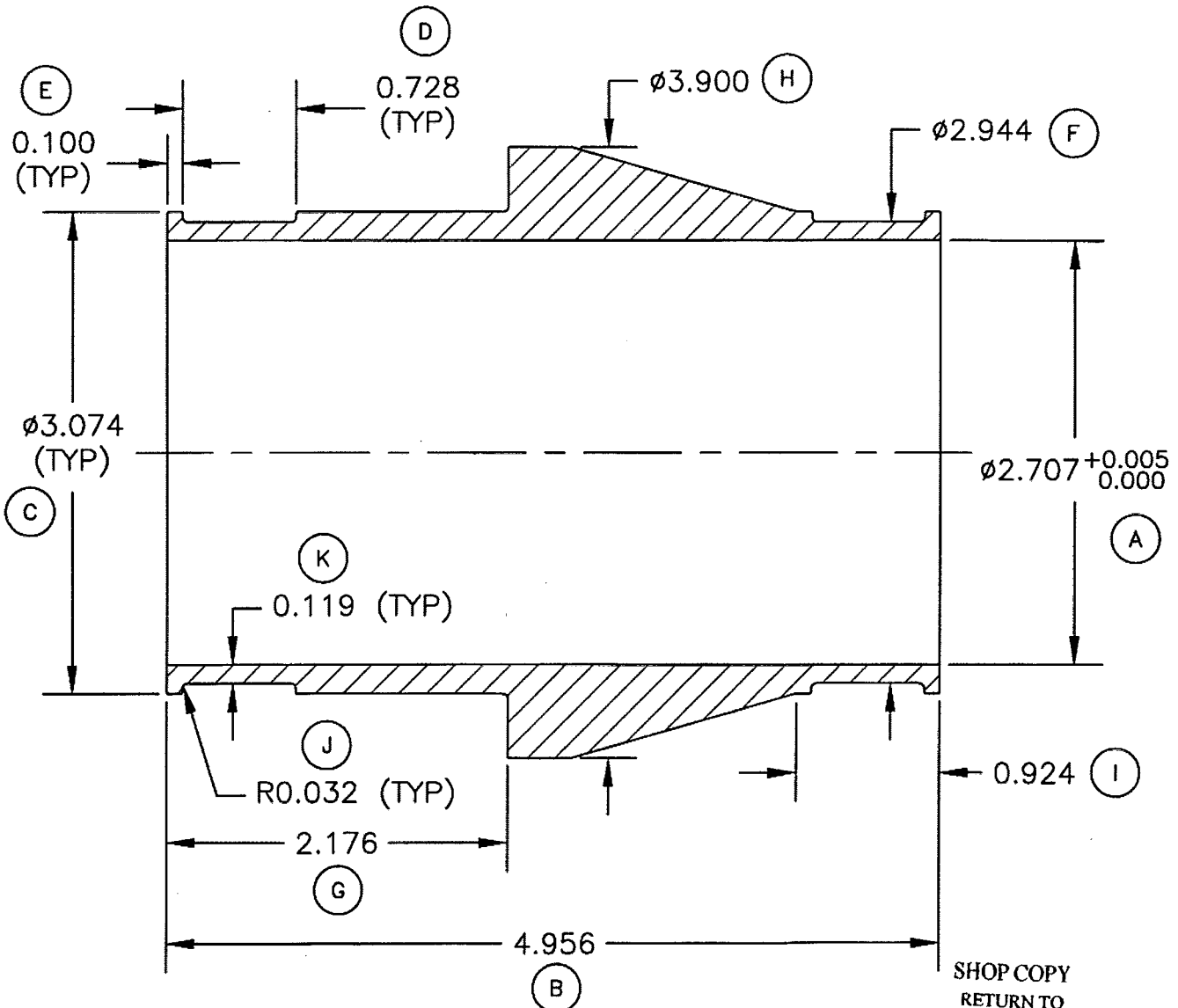
Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SA</u>

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ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

D2893-1 TURNING DETAIL

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WITHOUT NOTICE
WORK ORDER
NO. 47395

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